

CLAIMS

1. A horizontal packaging machine (10) for making fluid-tight packages (11) equipped with zip closure (15), the machine comprising:

- 5 - at least one unit (12) for unwinding a film (13) of synthetic material for packaging a series of products (18);
- at least one unit (14) for unreeling a pair of tapes (15) to form a zip closure;
- 10 - a shaping tunnel (16) located downstream of the film (13) unreeling unit (12);
- a sealing unit (20) located downstream of the shaping tunnel (16);

 whereby said machine, downstream of the sealing unit (20), comprises a power-driven film feed roller (21) designed to apply a uniform pulling force on the film (13) which is unwound and fed into the sealing unit (20).

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2. A machine (10) according to claim 1, wherein the power-driven feed roller (21) has on its lateral surface a series of jaws (33) for transversely sealing and separating the packages (11).

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3. A machine (10) according to claim 1, further comprising a device (19), located upstream of the sealing unit (20) and designed to cut the zip tape (15) in order to obtain portions (34) of film (13) without zip tape on them separating one package (11) from the next.

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4. A machine (10) according to claim 2, wherein the jaws (33) have cutting edges.

30 5. A machine (10) according to claim 1, further comprising a pair of opposite platforms (25), one on each side of the forward moving film (13) and zip tapes (15), each platform being equipped with two jaws (26, 27) designed to make a first continuous seal (28) along the outside

of the joined edges of the film (13) and a second seal (29) along the inside in order to attach the zip tape (15) to the film edges.

- 5 6. A machine according to claim 5, further comprising free turning guide rollers (30) for guiding the film (13) into the sealing unit (20).
7. A machine (10) according to claim 5, wherein one pair of jaws (26) feature a longitudinal groove which accommodates the zip tape (15) while the seal is being
10 made.
8. A machine (10) according to claim 1, further comprising, close to the unit (14) for unwinding the zip tape (15), a pair of unwinding rollers (23) driven by a servomotor (24).
- 15 9. A machine (10) according to claim 1, further comprising, downstream of the power-driven roller (21), it comprises a device (22) for collecting and feeding out the packages (11).
10. A machine (10) according to claim 1, further comprising
20 two process lines (35) placed side by side.